

Date: Wednesday, 4/4/2007 8:59:44 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : X-TUBE 412
 Job Number : 31599
 Estimate Number : 12727
 P.O. Number : N/A
 This Issue : 4/4/2007 S.O. No. : N/A
 Prsht Rev. : NC
 First Issue : N/A Type : LANDING GEAR
 Previous Run : 31598
 Part Number : D412664245
 Drawing Number : D412-664-245 U/R
 Project Number : N/A
 Drawing Revision : U/R
 Material : N/A
 Due Date : 4/30/2007 Qty: 1 Um: Each
 Written By :
 Checked & Approved By :
 Comment : Est Rev: A New Issue 07-02-14 JLM



Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D6009129 Crosstube Material



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part number Description Batch

1 D6009-129 Crosstube B-2911

Check OD = 3.500"; ID = 2.250"

JF 07/04/13

2.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy bluefile & type labels per PPPD412-664-205 CHG001

JF

3.0 MORI SEIKI MORI SEIKI CNC LATHE LARGE



Comment: MORI SEIKI CNC LATHE LARGE

Turn as per Dwg D412-664-245

JF 07/04/13

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

JF 07/04/13

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK

Er 07/04/17

H:\INFORMIS\120000

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 4/4/2007 8:59:44 AM

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: X-TUBE 412

Job Number: 31599

Part Number: D412664245

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Polish entire outside surface of crosstube

JB 7-4-18

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

JP 7-4-18

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

JB 7-4-18

9.0

QC3/5

INSPECT WORK/WING WALK



Comment: Inspect work & Chemical conversion Coat

JP 7-5-4

10.0

BENDING

BENDING MACHINE



Comment: BENDING MACHINE

Bend tube as per Dwg D412-664-243 using CNC bender program 412-af and Folio FT010

EL 7-5-7

11.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

JP 05-14-0

12.0

D36061

CUFF



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

CUFF

Batch: 31474

RT 07-05-23

13.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Drill Rivet holes as per Dwg D412-664-245

2-Drill pilot holes in tube as per Dwg D412-664-245

3-Ream hole to finish size in tube as per Dwg D412-664-245

RT 07-05-23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: X-TUBE 412

Job Number: 31599

Part Number: D412664245

Job Number:



Seq. #:

Machine Or Operation:

Description :

4-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D412-664-245

JD 7-5-14

HAND FINISHING1

HAND FINISHING RESOURCE #1

12.0



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat Tube & Cuffs as per QSI 005 4.1

JD 7-5-14

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION

13.0



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

QC5

INSPECT WORK TO CURRENT STEP

14.0



Comment: INSPECT WORK TO CURRENT STEP

OUTSIDE SERV.10

OUTSIDE SERVICES -LG

15.0



Comment: Sub-Contracting OUTSIDE SERVICES

Liquid Penetrant Inspection as per QSI 0380r

Issue P/O: 3781 LPI as per ASTM 1417

Level 2 Attach copy of NDT results to work order

C 207105115 ①

PACKAGING 1

PACKAGING RESOURCE #1

16.0



Comment: PACKAGING RESOURCE #1

Inspect for transit damage

Ensure copy of NDT results attached to work order.

C 207105116

QC5

INSPECT WORK TO CURRENT STEP

17.0



Comment: Inspect for damage & ensure results are as per Dwg D412-664-203

20.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Rivet Cuffs as per Dwg D412-6647-245. with Sika flex in Between tube & Cuff

A/R SIKAFLEX -241/-291 BATCH: 103497

25 07 05-23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 4/4/2007 8:59:45 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: X-TUBE 412

Job Number: 31599

Part Number: D412664245

Job Number:



Seq. #:

Machine Or Operation:

Description :

21.0

CR3212406

CHERRY RIVET



Comment: Qty.: 44.0000 Each(s)/Unit Total : 44.0000 Each(s)

CHERRY RIVET

Batch:

818164 / m10407

BT 07-05-23

22.0

SPRAY PAINTING

SPRAY PAINTING



Comment: SPRAY PAINTING

1-Prime inside and outside crosstube as per QSI 005 4.2

2-Paint outside crosstube with White Imron as per QSI 005 4.2

} BT 07-05-23

23.0

QC14

INSPECT SPRAY PAINT



Comment: Inspect Spray Paint

Wrap in plastic bag to protect from scratches

2005-24

24.0

D31891

Chafing Shield



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Chafing Shield

Batch:

31147

BT 07-05-25

25.0

D3595

Rubber Cushion (per sq ft)



Comment: Qty.: 0.0536 sf(s)/Unit Total : 0.0536 sf(s)

Rubber Cushion

Cut to .630" X 5.8" X 2PCS

Batch:

31948

BT 07-05-25

26.0

D28961

Support



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part number

Description Batch

1 D2896-1

Support

27266

BT 07-05-24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 4/4/2007 8:59:45 AM
User: Kim Johnston

Process Sheet

32176

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: X-TUBE 412

Job Number: 31599

Part Number: D412664245

Job Number:



Seq. #:

Machine Or Operation:

Description :

27.0

D2856600

Abrasion Strip



Comment: Qty.: 0.9450 f(s)/Unit Total : 0.9450 f(s)

Abrasion Strip

2 X D2856-600-1009

Batch:

26650

RT 07-05-25

28.0

MS2192028

Clamp(per MIL-DTL-8783C)



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part number Description Batch

4 MS21920-28

Clamp

107534

RT 07-05-25

29.0

MS2192032

clamp(per MIL-DTL-8783C)



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

clamp(per MIL-DTL-8783C)

batch: 102931

RT 07-05-25

30.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

Assemble as per Dwg D412-664-245

Install Chaffing Shields

Instal support with magnobond 6398 per dwg D412-664-245,
cure for 12hrs before packaging.

Time & date of application: 5:00 pm 07-05-24

Batch:

103628

RT 07-05-25

31.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

7-05-25 (1)

32.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D412-664-205

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: X-TUBE 412

Job Number: 31599

Part Number: D412664245

Job Number:



Seq. #:

Machine Or Operation:

Description :

*****Ensure tube is not packaged if curing time is less than 12 hrs, see step 27 for application time & date

Time & date of packaging:

Location: _____

PPP Rev: _____

POSITIVE RECALL

EFFECTIVE 07/04/04 AUTH UP

RELEASED 6 DATE 07-05-25

33.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/05/05 ①

Job Completion



07-05-25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN <i>92</i>	DRAWN BY <i>92</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D412-664-245	REV. B SHEET 1 OF 3
DATE 07.03.01		TITLE CROSSTUBE ASS'Y (412 LOW-N AFT) NTS	
A	06.12.01	NEW ISSUE	
B	07.03.01	CHG CUFF AREA, CHG RUBBER CUSHION	

PRELIMINARY ISSUE

PARTS LIST:

Qty	Part Number	Description
X	D412-664-245	CROSSTUBE ASSEMBLY (412 LOW-NARROW AFT)
1	D6009-129	CROSSTUBE
2	D2856-600-1009	ABRASION STRIP
1	D2896-1	SUPPORT
2	D3189-1	CHAFING SHIELD
2	D3595-063-580	RUBBER CUSHION
2	D3606-1	CUFF
44	CR3212-4-06	RIVET (OR M7885/3-4-06)
4	MS21920-28	CLAMP
2	MS21920-32	CLAMP
A/R	MAGNOBOND 6398	ROCKWELL SPECIFICATION RBO-120-023 ADHESIVE (TEXTRON/BELL SPEC. 299-947-100, TYPE II, CLASS 2 ADHESIVE)
A/R	SIKAFLEX-241/-291	SEALANT (OR PROSEAL 890 OR MIL-S-8802 CLASS B2 SEALANT)

GENERAL NOTES:

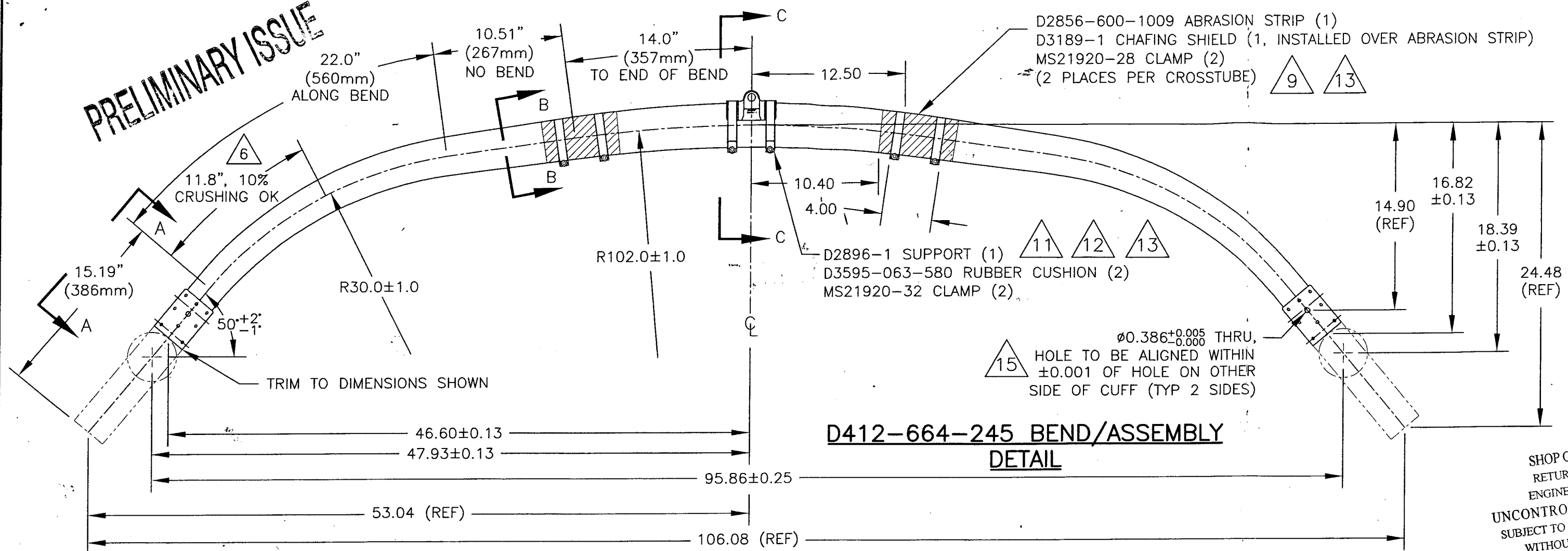
- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 2) MATERIAL: MANUFACTURED FROM D6009-129
FINISHED LENGTH = 123.59±0.020 (BEFORE BENDING/TRIMMING)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
PAINT OUTSIDE PER DART 005 4.2
- 4) PART IS SYMMETRIC ABOUT CENTERLINE.
- 5) RUN-OFF PART. BLEND OUT EDGE LONGITUDINALLY, TRANSITION SHOULD BE SMOOTH.
- 6) BEND PROGRESSIVELY WITH A MINIMUM OF 8 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D., EXCEPT UP TO 10% IS ALLOWED IN AREA NOTED.
- 7) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
- 8) SCRIBE DART PART NUMBER AND BATCH NUMBER IN THIS AREA WITH VIBRATING STYLUS.
- 9) INSTALL D2856-600-1009 ABRASION STRIP WITH A 0.13 (REF) GAP ON BOTTOM SIDE OF CROSSTUBE PER QSI 035.
- 10) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 11) APPLY A 0.03" TO 0.06" THICK LAYER OF MAGNOBOND 6398 TO THE SURFACE OF D2896-1 THAT WILL BE IN CONTACT WITH THE CROSSTUBE. LET CURE FOR 12 HOURS AFTER INSTALLATION AND PRIOR TO PACKAGING.
- 12) INSTALL MS21920-32 CLAMPS WITH D3595-063-580 RUBBER CUSHIONS TO SECURE D2896-1 SUPPORT ON TOP SIDE OF THE CROSSTUBE. ENSURE CLAMPS ARE OPPOSITE CROSSTUBE SUPPORT.
- 13) TORQUE CLAMPS 80 TO 100 IN-LB.
- 14) INSTALL D3606-1 CUFF AFTER CHEMICAL CONVERSION COAT BUT BEFORE PAINT, WITH LAYER OF SIKAFLEX-241/-291 OR PROSEAL 890 OR MIL-S-8802 CLASS B2 SEALANT BETWEEN CUFF AND CROSSTUBE.
- 15) TOUCH-UP HOLES WITH CHEMICAL CONVERSION COAT.

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SUBMIT TO AMENDMENT
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WORK ORDER
NO. 31599

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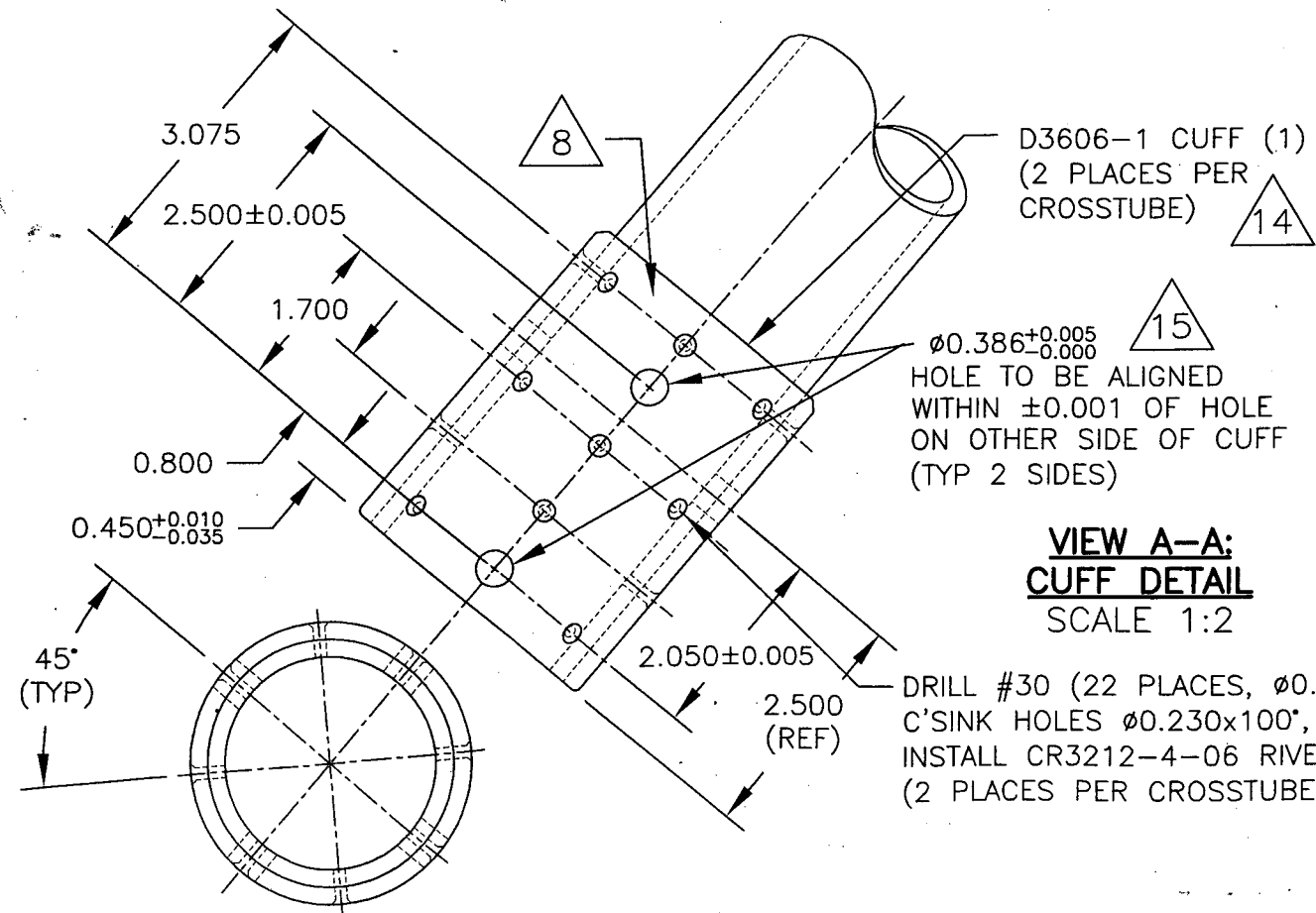
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PRELIMINARY ISSUE

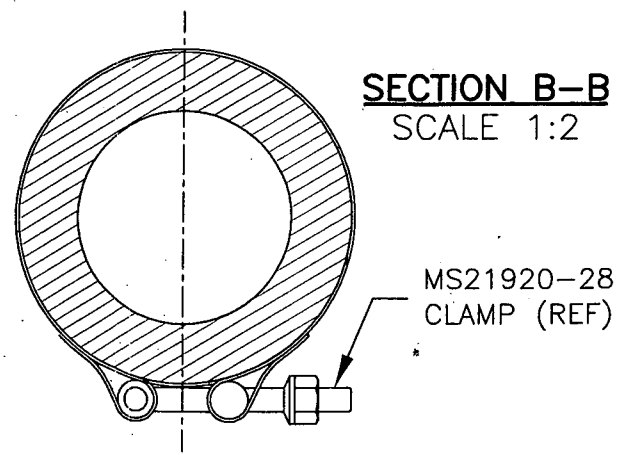


**D412-664-245 BEND/ASSEMBLY
DETAIL**

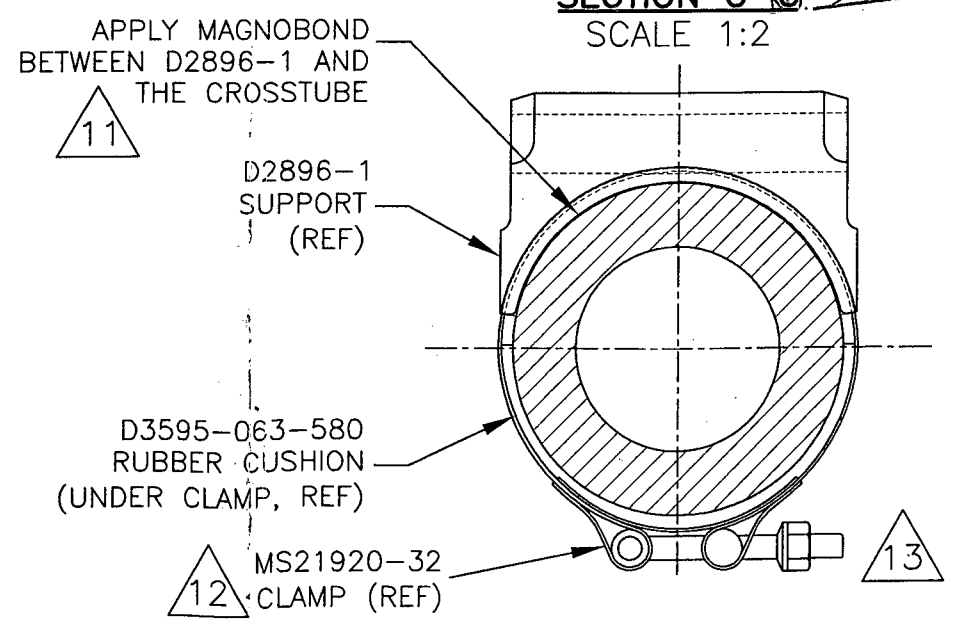
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WORK ORDER
31599



**VIEW A-A:
CUFF DETAIL
SCALE 1:2**

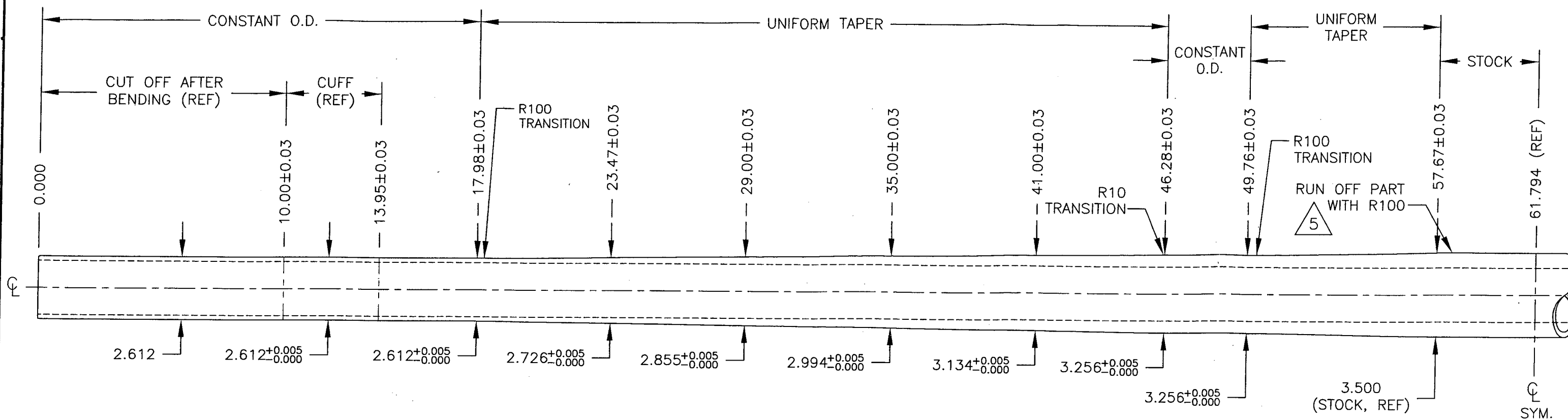


**SECTION B-B
SCALE 1:2**



**SECTION C-C
SCALE 1:2**

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DATE		07.03.01		DRAWING NO.	REV. B
				D412-664-245	SHEET 2 OF 3
				TITLE	SCALE
				CROSSTUBE (412 LOW-NARROW AFT)	1:8



D412-664-245 MACHINING DETAIL

PRELIMINARY ISSUE

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WORK ORDER
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DATE		07.03.01		DRAWING NO.	REV. B
				D412-664-245	SHEET 3 OF 3
				TITLE	SCALE
				CROSSTUBE (412 LOW-NARROW AFT)	1:4

DART AEROSPACE LTD		Work Order: 31599
Description: X Tube 412		Part Number: 0412664245
Inspection Dwg: 0412664245 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

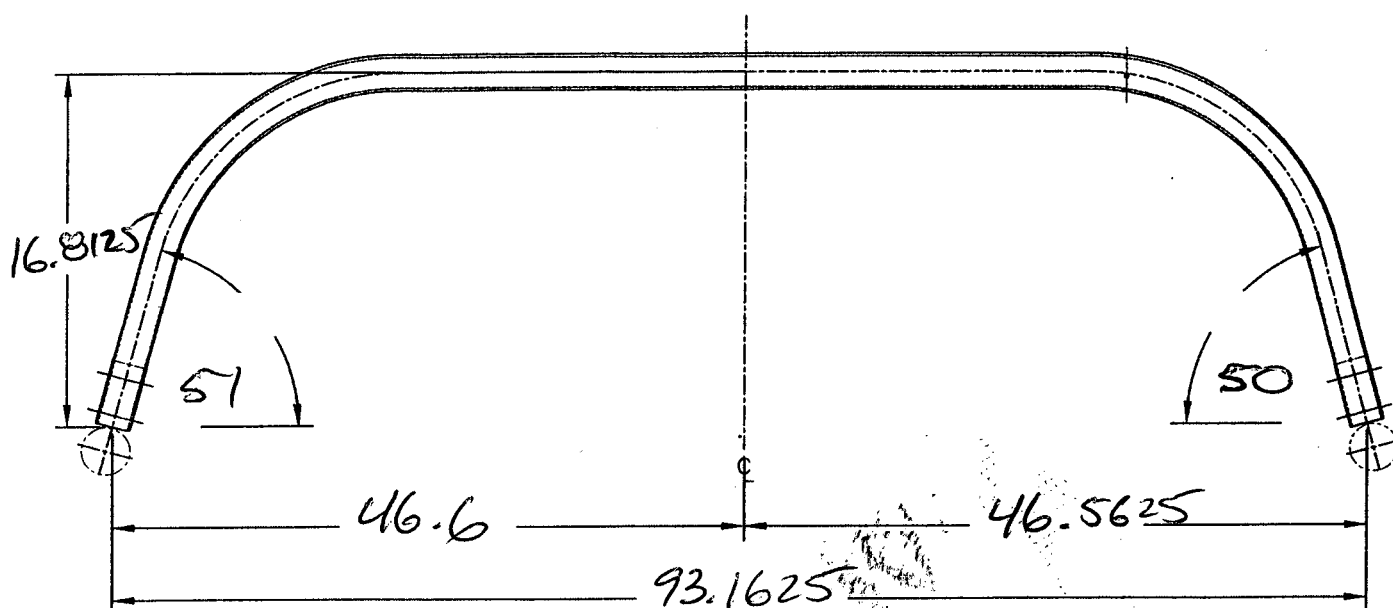
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
2.612	+0.005 -0.000	2.612	✓			
2.612	"	2.615	✓			
2.612	"	2.615	✓			
2.726	"	2.731	✓			
2.855	"	2.860	✓			
2.994	"	2.998	✓			
3.134	"	3.138	✓			
3.256	"	3.261	✓			
3.256	"	3.261	✓			
3.500	"	3.500	✓			
2.612	"	2.612	✓			
2.612	"	2.615	✓			
2.612	"	2.615	✓			
2.726	"	2.731	✓			
2.855	"	2.860	✓			
2.994	"	2.998	✓			
3.134	"	3.138	✓			
3.256	"	3.261	✓			
3.256	"	3.261	✓			
3.500	"	3.500	✓			
123.588	+0.030	123.588	✓			

Measured by: JF	Audited by: En	Prototype Approval:
Date: 07/04/17	Date: 07/04/17	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

DART AEROSPACE LTD		Work Order:	31579
Description: Crosstube Low Narrow Aft (412)		Part Number:	D412-664-205
Inspection Dwg: D412-664-245 Rev: C		Page 1 of 1	

Required Dimension	Min	Max
Height	16.69	16.95
1/2 Span	46.47	46.73
Angle	49°	52°
Total Span	92.94	93.46



Comments

QC15 Inspection	<i>[Signature]</i> 0705-24
Date	

Rev	Date	Change	Revised by	Approved
A	07.04.27	New Issue	KJ/JM	

**HeathAir**

INTERNATIONAL (1991) INC.

681 Ave. Lapine, Dorval, Québec H9P 1G3
Tél.: (514) 636-1000 • Fax: (514) 636-0031

W.O. N° 36413

A.M.O. Number: 46/90

NON-DESTRUCTIVE TESTING REPORT**AIRCRAFT / COMPONENT INFORMATION**

REGISTRATION:

MODEL/TYPE:

SERIAL NUMBER:

TOTAL HR/LDG:

OPERATED BY:

BASED AT:

INSPECTION REQUIREMENTS

Carry out FPI of (4) cross tubes (external surface) as per ASTM E-1417-05 and the Dart QSI 038, Section 4.1.1 (on file at client) - parts delivered to HeathAir.

Qty (1) P/N D407-667-205 S/N B31039
Qty (1) P/N D412-664-145 S/N B31601
Qty (2) P/N D412-664-245 S/N B31599 and B31597.

☐ RADIOGRAPHY☐ ULTRASONIC☒ PENETRANT☐ MAGNETIC PARTICLE☐ EDDY CURRENT**INSPECTION REPORT**

Fluorescent penetrant inspection was performed in accordance with the above requirements on (4) Cross Tubes.

Note: A Level 3 penetrant was substituted for the requested Level 2 (3 is more sensitive) Ardrex 970P25E Batch #04B503.

(4) cross tubes inspected. (4) PASSED inspection / (0) FAILED inspection.

THE MAINTENANCE DESCRIBED ABOVE HAS BEEN PERFORMED IN ACCORDANCE WITH
THE APPLICABLE STANDARDS OF AIRWORTHINESS

INSPECTED BY:

DATE May 15, 2007

INSPECTION
STAMP(S) **CUSTOMER INFORMATION**

CUSTOMER: Dart Aerospace

P.O. NUMBER

3781

ADDRESS: Fax. 613-632-1053

CONTACT NAME:

Linda

LABOUR

MATERIALS

TRAVEL EXPENSES

HOTEL EXPENSES

INVOICE NO.

TOTAL \$

WHITE COPY - INSPECTION FILE • YELLOW COPY - CUSTOMER • PINK COPY - ACCOUNTANT